

Page 1

Quality Control

ent 12/06/11



12-06-14 (x4)

45 12-06-14 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84303

May-09-12 1:36:52 PM

84303

Page 2

Item ID: D3524-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Upper Plate Assembly

Stop ***NS2***

Start Date: 09/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 23/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

SL 12-06-15

130

QC

Memo

0.00

(H)

Quality Control

140

Small Fab

0.00

140

Small Fab

Memo

0.00

4x

12/06/18

Small Fab

C'SINK AS PER DWG D3524

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

8/2/06/18

(H)

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

84303

Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

4

Cust Item ID:

4

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

0.00

160

HandFinish

Hand Finishing

Memo

0.00

170

0.00

170

Small Fab

Small Fab

Small Fab

Memo

0.00

RIVET NUT PLATES AS PER DWG D3524

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Quality Control

Memo

0.00

5/17/2019

44

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Page 4

May-09-12 1:36:52 PM

```
Setup  Start  *NS1*
      Stop  *NS2*
```

Cust Item ID:
Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

2/20/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-09-12 1:36:56 PM

Page 1

Work Order ID: 84303

84303

Parent Item: D3524-041

D3524-041

Parent Item Name: Upper Plate Assembly

Start Date: 09/05/2012

Required Date: 23/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-09-24 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS20426AD3-4

Purchased

No

100

Each

3,280.000

8

32

MS20426AD3-4

RIVET

**

Location

Loc Qty

Loc Code

ST316

3280

104374

614

110398

2666

M6061T6B0.375X03.00

Purchased

No

170

f

14.1800

0.3082

1.297684

M6061T6B0 375X03 000

6061T6 BAR .375 X 3.00

**

Location

Loc Qty

Loc Code

MAT001

14.18

105225

4.6

18237

9.58

MS21075L06

Purchased

No

170

Each

47.0000

4

16

MS21075L 06

ANCHOR NUT

**

Location

Loc Qty

Loc Code

ST303

47

105978

47

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	84303
Description: upper plate		Part Number:	03524-3
Inspection Dwg: 03524 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+/- .030	1.251	✓		vern	RT - 4
2.50	+/- .070	2.502	✓			
2.800	+/- .010	2.800	✓			
.35	+/- .030	.350	✓			
1.800	+/- .010	1.798	✓			
.35	+/- .030	.348	✓			
3.50	+/- .030	3.501	✓			
1.75	+/- .030	1.75	✓			
.345	+/- .010	.347	✓			
.210	+/- .005	.209	✓			
.750 ref	+/- .010	.747	✓			
.270 ref	+/- .010	.271	✓			
.075	+/- .010	.076	✓			
.375	+/- .010	.375	✓			
Ø.098		.098	✓			
.375	+/- .010	.373	✓			
1.625	+/- .010	1.626	✓			
.94	+/- .030	.937	✓			
.72	+/- .030	.715	✓			
1.063	+/- .010	1.066	✓			
Ø.129		.129	✓			
.218	+/- .010	.220	✓			
Ø.144		.146	✓			

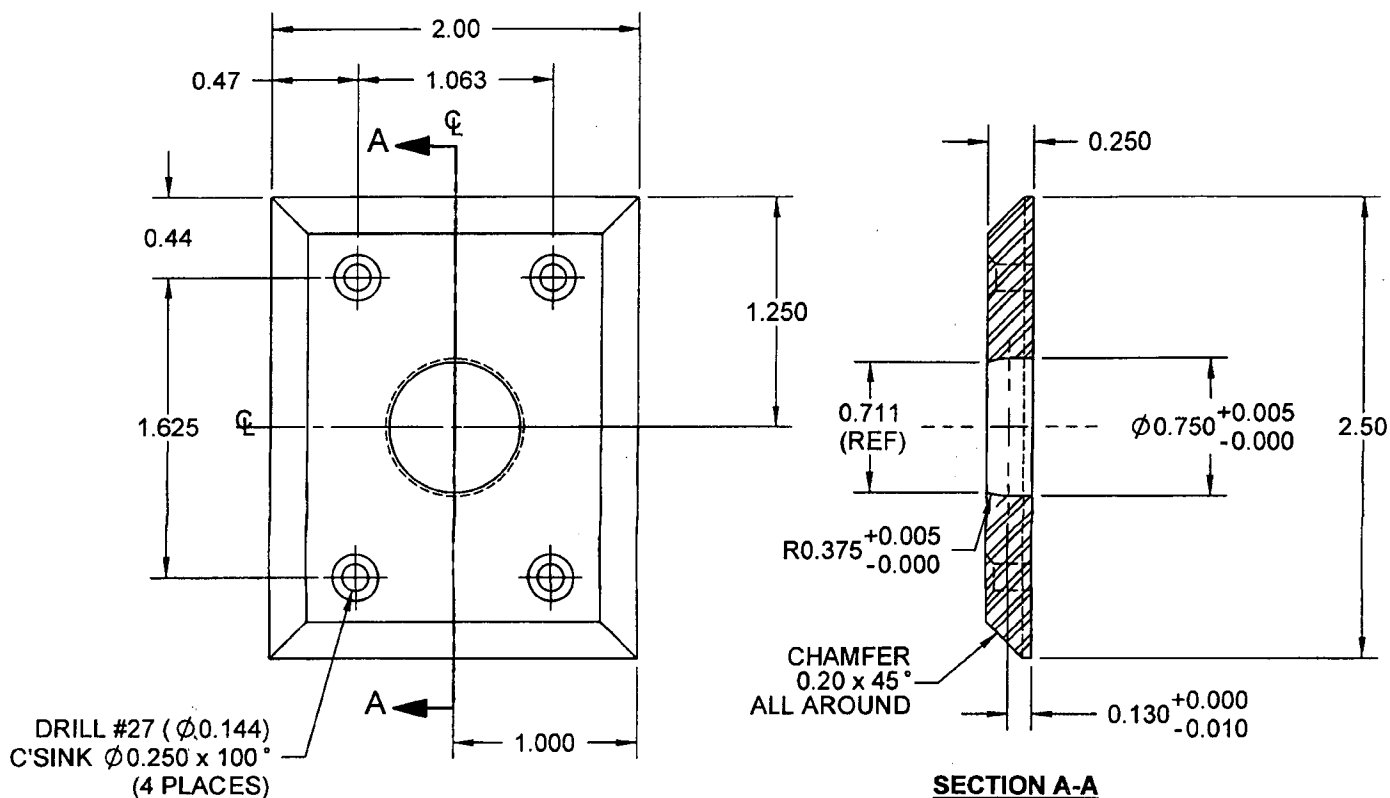
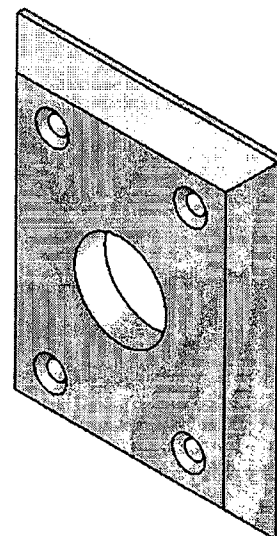
Measured by: RT	Audited by: SL	Preliminary Approval:
Date: 12-06-14	Date: 12-06-15	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3524	REV. A SHEET 1 OF 3
DATE 07.07.24	TITLE UPPER AND LOWER PLATE		SCALE 1:1
REV A	DATE 07.07.24	DESCRIPTION NEW ISSUE	

**D3524-1 LOWER PLATE****RELEASED**
07.08.03

1205/09
NO. 07303 MJS
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
RETURN TO
ENGINEERING
SHOP COPY

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART SYMMETRIC ABOUT ϕ

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

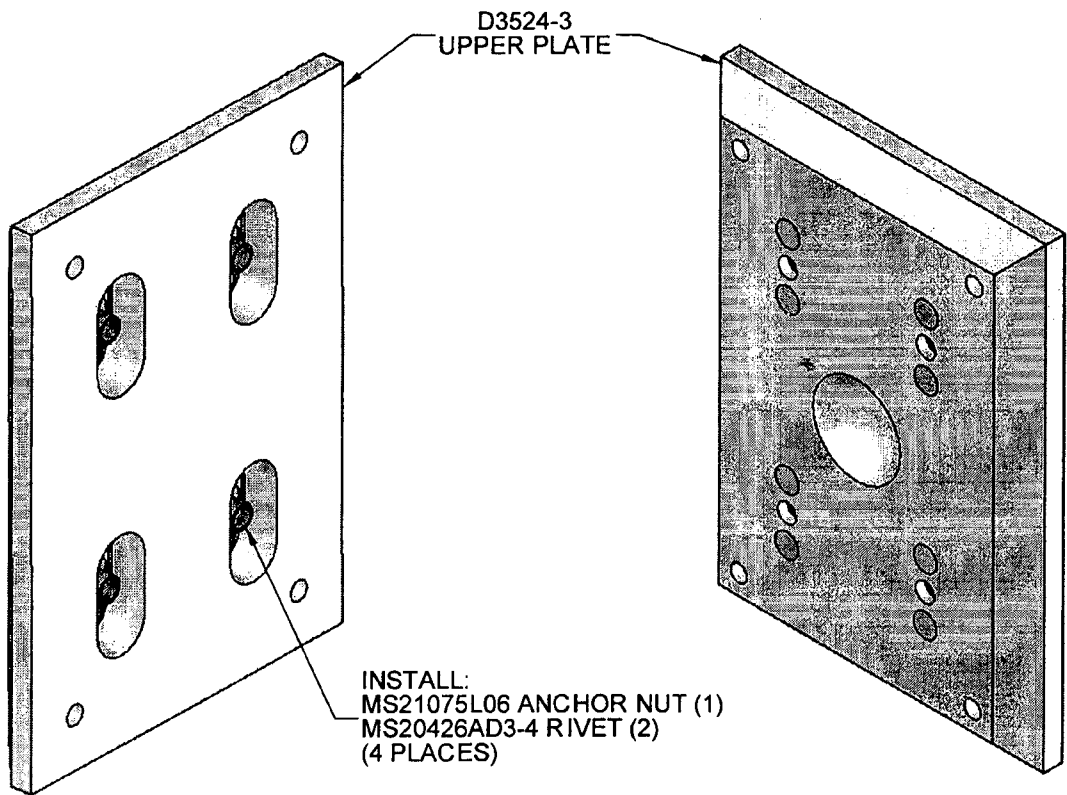
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3524	REV. A SHEET 2 OF 3
DATE 07.07.24		TITLE UPPER AND LOWER PLATE	SCALE 1:1



INSTALL:
MS21075L06 ANCHOR NUT (1)
MS20426AD3-4 RIVET (2)
(4 PLACES)

D3524-041 UPPER PLATE ASSEMBLY

RELEASED
07.08.03 **[Signature]**

PARTS LIST:

QTY	PIN	DESCRIPTION
X	D3524-041	UPPER PLATE ASSEMBLY
1	D3524-3	UPPER PLATE
4	MS21075L06	ANCHOR NUT
8	MS20426AD3-4	RIVET

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84303

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

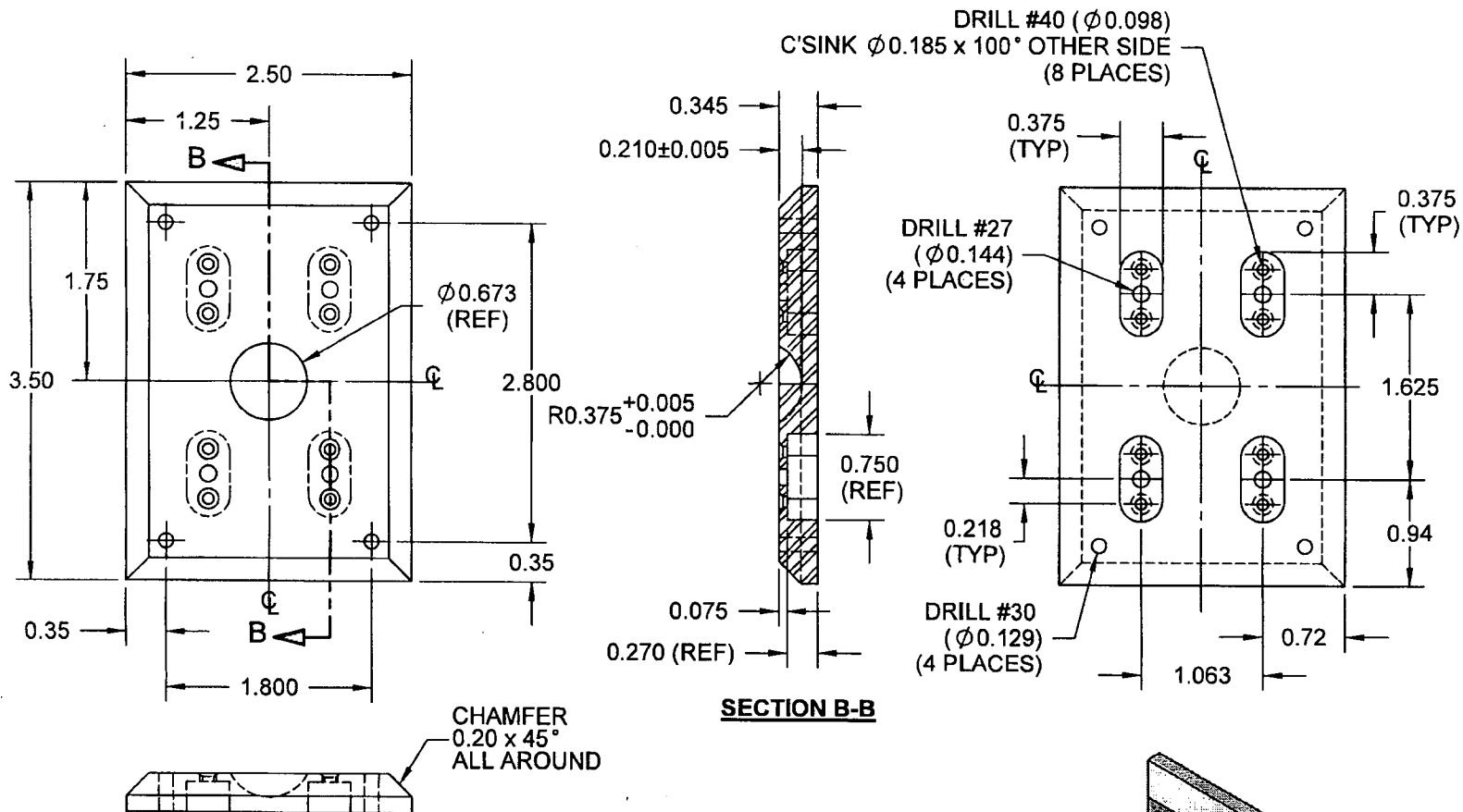
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CE	APPROVED	[Signature]	DRAWING NO. D3524
DATE	07.07.24	TITLE	UPPER AND LOWER PLATE	REV. A SHEET 3 OF 3 SCALE 2:3



D3524-3 UPPER PLATE

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
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- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART SYMMETRIC ABOUT ϕ

RELEASED
07.08.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes- No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries